

Work Order ID 141003

Tuesday, January 26, 2016 3:18:06 PM

141003

Page 1

Item ID: 647.1702

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skid Deflector Assembly

Stop ***NS2***

Start Date: 1/26/2016 Start Qty: 200

D

Cust Item ID:

Required Date: 1/26/2016 Req'd Qty: 200

D

Customer:

Reference:

Approvals: Process Plan: MCS Date: JAN 28 2016

Tooling:

Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.1700	D								

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

120

Small Fab

Small Fab

Memo

1- Assemble item 4,6,7 and 8 as per dwg.

2- Clamp item 1 and 2 to item 3. Transfer drill holes as per dwg see note 6. Use clecos.

3- Disassemble parts

4- Deburr

5- Touch up expose aluminum with alodine

6- Re-assemble as per dwg

DAS
36
9-89

16/02/02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Page 2

FEB 04 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

Work Order ID 141003

Tuesday, January 26, 2016 3:18:06 PM

141003

Page 3

Item ID: 647.1702

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skid Deflector Assembly

Start Date: 1/26/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/26/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190		0.00							
190									
Small Fab	Memo	0.00							
Small Fab	ASSEMBLE AS PER DWG	DAS 38 9-89							
200		0.00							
200									
QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	DAS 38 9-89							
210		0.00							
210									
Packaging	Identify as per dwg & Stock Location: CC/C033	0.00							
Packaging	Memo	0.00							
	IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV								

DAS
6
9-89

FEB 04 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

Work Order ID 141003

Tuesday, January 26, 2016 3:18:06 PM

141003

Page 4

Item ID: 647.1702

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skid Deflector Assembly

Start Date: 1/26/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/26/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
Number
FEB 04 2016Insp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

MLJ

MLJ

FEB 04 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Description Work Order Deviation		Disposition			
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OTHER : ☐					

Picklist Print

Tuesday, January 26, 2016 3:18:05 PM

Page 1

Work Order ID: 141003

141003

Parent Item: 647.1702

647 1702

Parent Item Name: Skid Deflector Assembly

Start Date: 1/26/2016

Required Date: 1/26/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13.07.17 JLM VERIFIED BY:DD IPP
REV:B 14.09.26 AS PER DWG C1 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21042-3	MS21042L3	Purchased	No				Each	18.0000		2 1/2	133790		DAS 6 9-89
MS21042-3									**				

Nut / use MS21042L3

Location	Loc Qty	Loc Code
ST304	18	
M129682	18	

647.1712		Manufactured	No				Each	4.0000		2 1/2			DAS 6 9-89
647 1712									**				

Gusset

Location	Loc Qty	Loc Code
CCK036	4	
135512	4	

647.1713		Manufactured	No				Each	45.0000		4 1/2			DAS 6 9-89
647 1713									**				

Spacer

Location	Loc Qty	Loc Code
CCK108	45	
104845	36	
99057	9	

601.1915	CR3213-4-4	Purchased	No				Each	0.0000		4 1/2	8382		DAS 6 9-89
601 1915									**				

Rivet (CR3213-4-4)

3213-4-64

126282
132825 X10
133694 V122

JAN 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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		OTHER : ☐			

Picklist Print

Tuesday, January 26, 2016 3:18:05 PM

Page 2

Work Order ID: 141003

141003

Parent Item: 647.1702

647 1702

Parent Item Name: Skid Deflector Assembly

Start Date: 1/26/2016

Required Date: 1/26/2016

Start Qty: 2.00

Required Qty: 2.00

601.1607 NAS1149F0332P Purchased No

Each 19.0000

601 1607

Washer (NAS1149F0332P)

**

DAS
6
9-89

133938

Location

Loc Qty

Loc Code

ST522

19

m123185

19

601.1622 MS27039-1-14 Purchased No

Each 0.0000

601 1622

Screw (MS27039-1-14)

**

DAS
6
9-89

124326

647.1714 Manufactured No

Each 14.0000

647 1714

Plate

**

DAS
6
9-89

Location

Loc Qty

Loc Code

CCK044

14

125132

2

126237

6

135635

6

647.1715 Manufactured No

Each 13.0000

647 1715

Plate

**

DAS
6
9-89

Location

Loc Qty

Loc Code

CCK044

13

125320

2

126238

6

135636

5

JAN 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

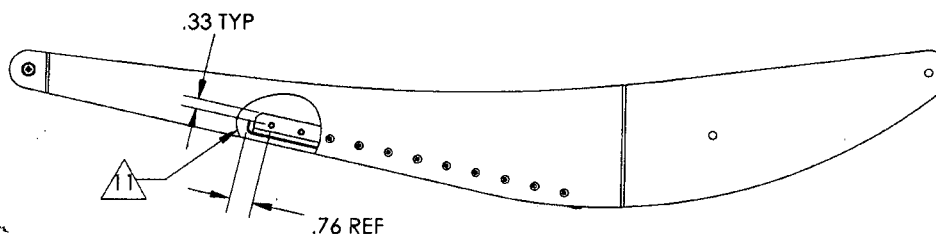
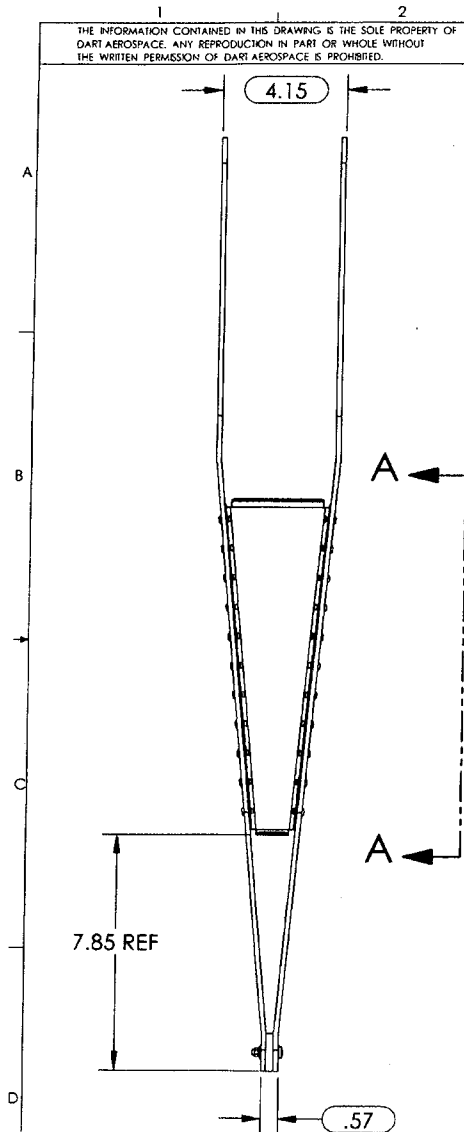
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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		OTHER : ☐							

QTY		PARTS LIST	
NEXT ASSY (S)		 3030 ENTERPRISE C1 SUITE A VISTA, CA 92081 (760) 724-5300	
647.1300		APICAL AEROSPACES INC 800 DART AEROSPACE	
OFFICIAL DATE (TWO-DIGIT) DEPOSIT DRAWN BY J. GARDNER CHECKED BY P. BRAVO DRAWING APPROVAL DEPT 007 00000000 CONTRACT NO.		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1. 9 PLACE DECIMALS .01 2. 9 PLACE DECIMALS .005 3. 9 PLACE DECIMALS .005 4. 9 PLACE DECIMALS .005 5. 9 PLACE DECIMALS .005	
PART 647.1700		SKID DEFLECTOR ASSY CAGE CODE 07M16 DWO. NO. 647.1700	
SCALE NONE		SHEET 1 OF 7	

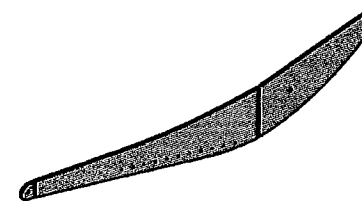
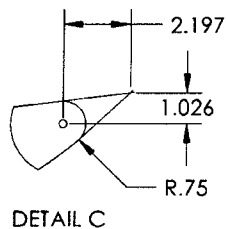
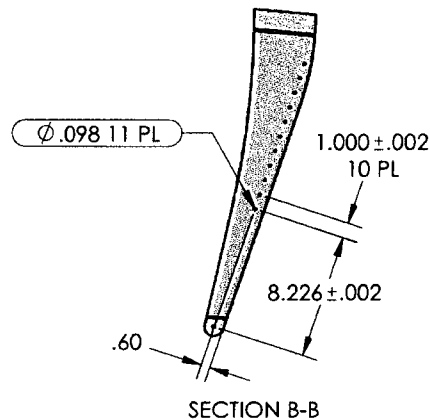
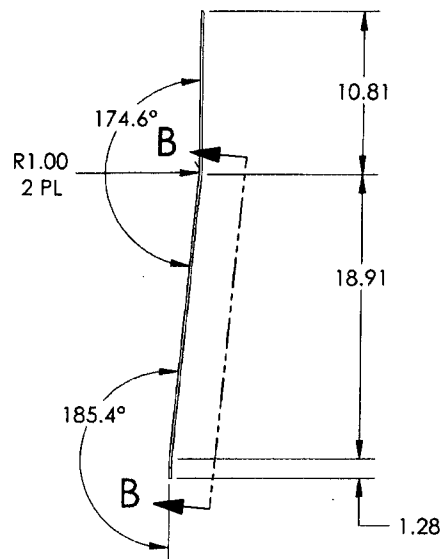
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF DART AEROSPACE. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE IS PROHIBITED.



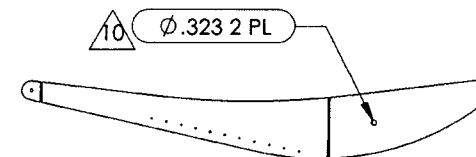
SECTION A-A

ORIGINAL DATE 06/05/09		3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760) 724-5300	
DRAWN BY J. CAHNEY	CHECKED P. BRAVO	DART AEROSPACE APICAL INDUSTRIES, INC. 0800 DART AEROSPACE	
DRAWING APPROVAL P. BRAVO			
CONTRACT NO.		SKID DEFLECTOR ASSY UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°	
SRE B	CAGE CODE 07M16	QWG NO. 647.1700	REV. D
SCALE NONE		SHEET 2 OF 7	

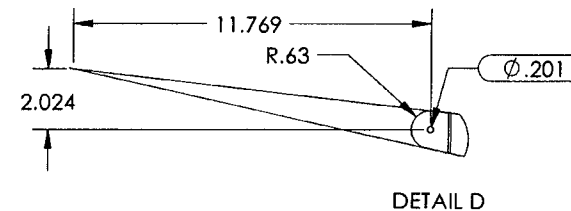
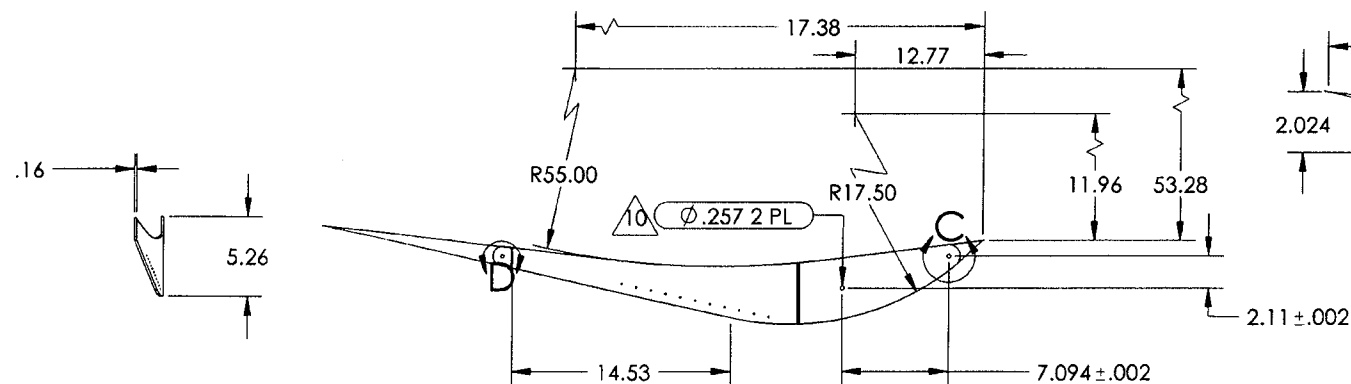
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647.1711 SHOWN
647.1710 OPPOSITE



647.1714 SHOWN
647.1715 OPPOSITE

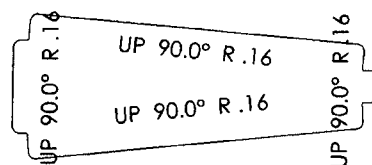
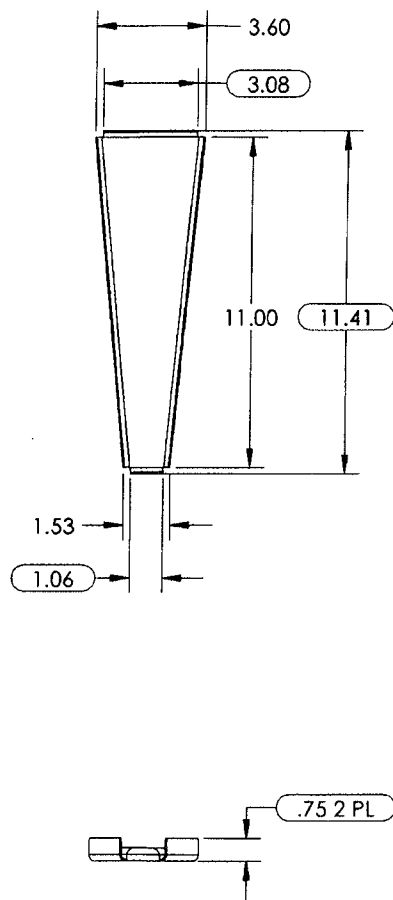


ORIGINAL DATE JUN 04 1971		DESIGNER J. C. BOWEN		CHECKER P. BRAVO	
DRAWN BY J. C. BOWEN		DESIGNER J. C. BOWEN		CHECKER P. BRAVO	
DRAWING APPROVAL P. BRAVO		DESIGNER J. C. BOWEN		CHECKER P. BRAVO	
CONTRACT NO.		CAGE CODE 07M26		DWG. NO. 647.1700	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SCALE: NONE		SHEET 3 OF 7	

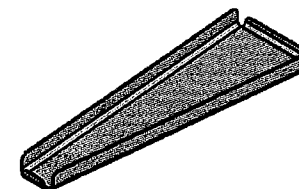
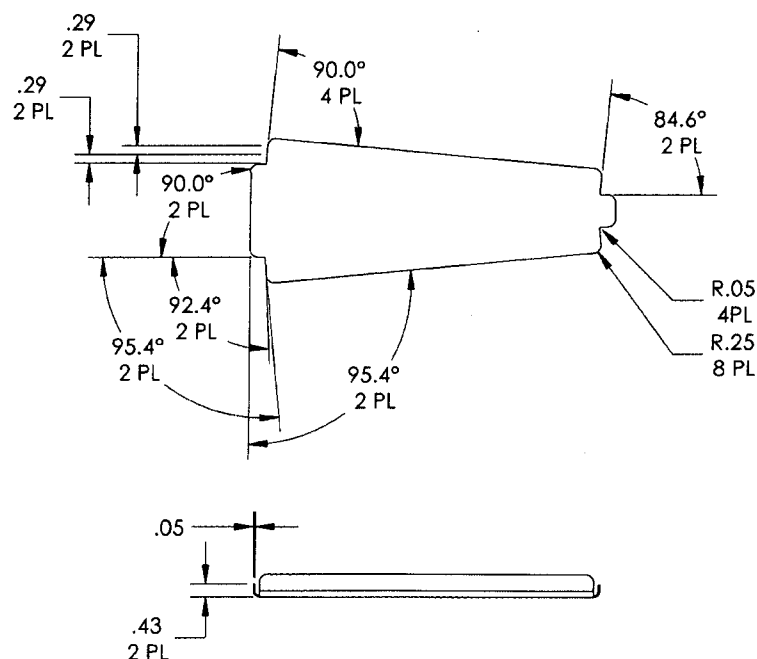
DART AEROSPACE 3030 ENTERPRISE CT., SUITE A
VISTA, CA 92081
(760) 691-9108
APCAL INDUSTRIES, INC.
DBO DART AEROSPACE

SKID DEFLECTOR ASSY

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FLAT PATTERN



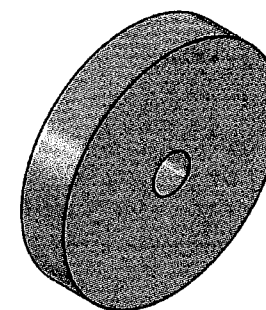
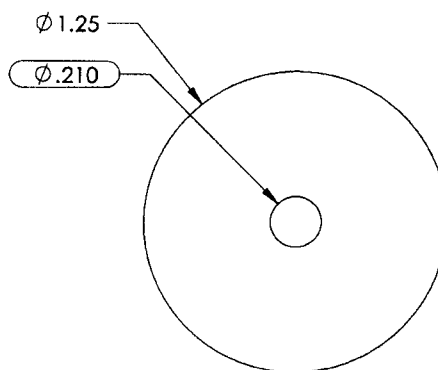
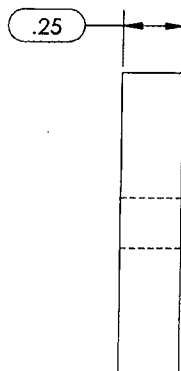
647.1712

ORIGINAL DATE 11/03/00		DESIGNED BY J. GARDNER		CHECKED BY P. BRAVO	
DRAWN BY J. GARDNER		APPROVED BY P. BRAVO		CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°					
SIZE B	CAGE CODE D7M16	DWG. NO. 647.1700	REV. D	SHEET 4 OF 7	
SCALE NONE					

DART 3030 ENTERPRISE CT., SUITE A
AEROSPACE VISTA, CA 92081
APCAL INDUSTRIES, INC.
(760) 724-5300

SKID DEFLECTOR ASSY

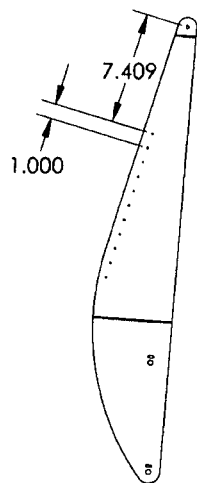
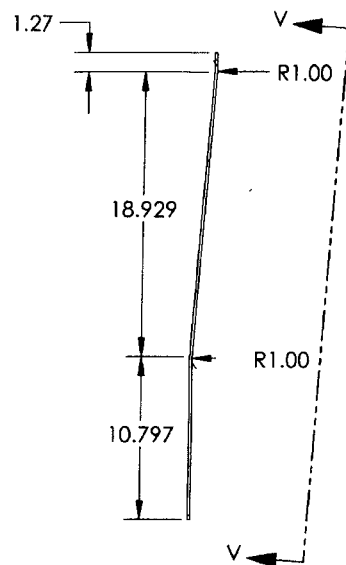
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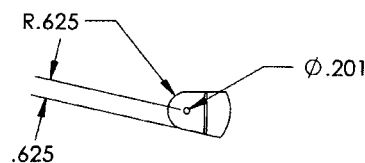
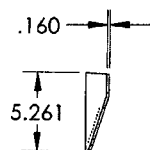
647.1713

ORIGINAL DATE JUL 25, 1991		DESIGNER C. HICKER		3030 ENTERPRISE CT.	
DRAWN BY J. GARDNER		P. BRAVO		SUITE A	
DRAWING APPROVAL P. BRAVO				VISTA, CA 92081	
CONTRACT NO.				(760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ± .01 ANGLES 3°		CAGE CODE 07M26		DWG. NO. 647.1700	
SCALE NONE		REV. D		SHEET 5 OF 7	

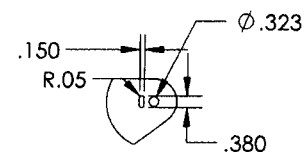
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VIEW V-V

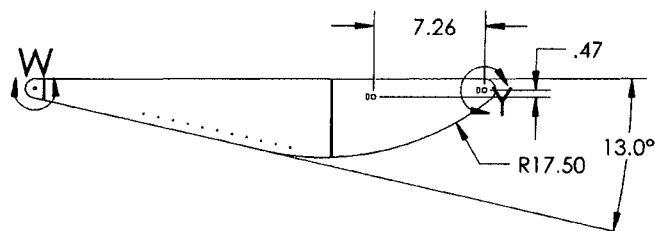


DETAIL W



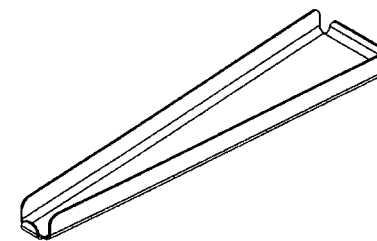
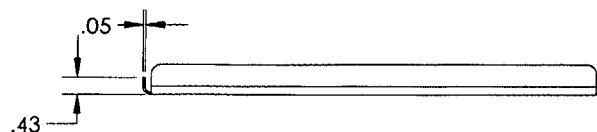
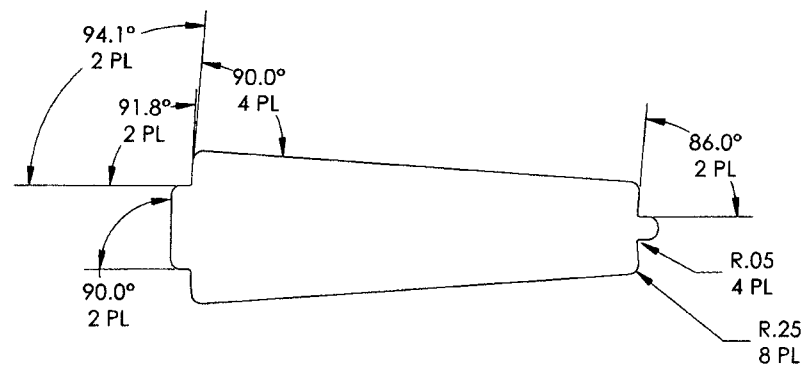
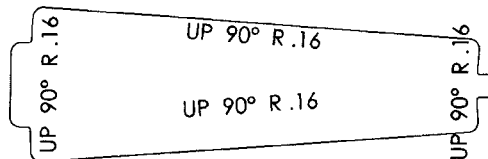
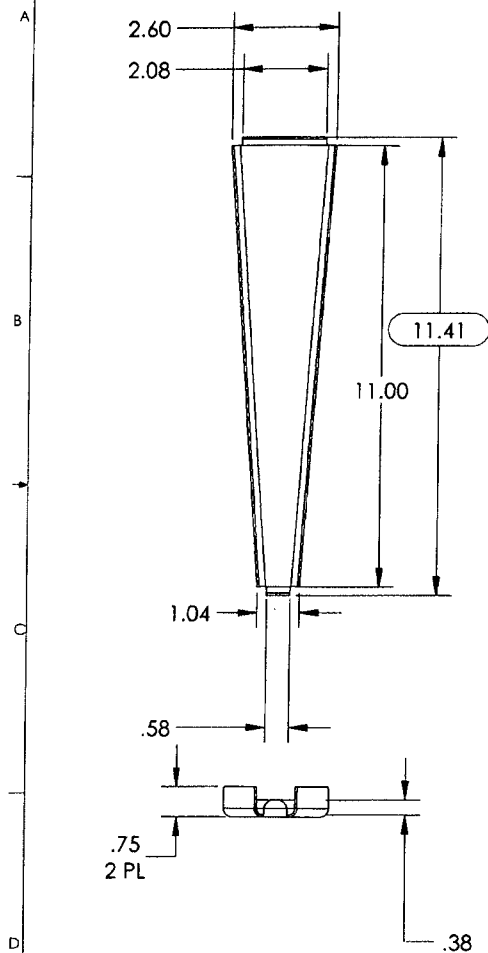
DETAIL Y
TYP 2 PL

647.1716 SHOWN
647.1717 OPPOSITE



ORIGINAL DATE 08-03-09		3030 ENTERPRISE CT., SUITE A VISTA, CA 91081 (760) 724-5300	
DRAWN BY S. HUFF	CHECKER P. BRAYVO	DART AEROSPACE AFICAL INDUSTRIES, INC. 6550 DART AEROSPACE	
DRAWING APPROVAL P. BRAYVO			
CONTRACT NO.		SKID DEFLECTOR ASSY SITE: CAGE CODE: 07M16 DWG. NO: 647.1700 REV. D SCALE: NONE SHEET: 6 OF 7	

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647.1718

ORIGINAL DATE (MO, DA, YR) 08-05-07		3030 ENTERPRISE CT. SUITE A VISTA CA, 92081 (760) 724-5300	
DRAWN BY S. HUBB	CHECKER P. BRAVO	DART AEROSPACE	
DRAWING APPROVAL P. BRAVO		AFICAL INDUSTRIES INC. 2001 DART AEROSPACE	
CONTRACT NO.		SKID DEFLECTOR ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE B	REV. D
CAGE CODE 07M16		DWG. NO. 647.1700	
SCALE NONE		SHEET 7 OF 7	